

TRANS-119 mirrors A4A

Dart Aerospace Ltd.

Date: Wednesday, 27/02/2008 7:40:20 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET R/H
Job Number : 37636	
Estimate Number : 11550	
P.O. Number :	Part Number : D30722
This Issue : 27/02/2008 S.O. No. :	Drawing Number : D3072 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 37636	Material :
Written By :	Due Date : 14/03/2008 Qty: 20 Um: Each
Checked & Approved By :	
Comment : Est. B02.01.18 Flat pattern created on dash 101. NG Est Rev:C 08-02-26 now water jet DD verified by:LL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S090	5052-H32 .090 Sheet
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Comment: Qty.: 0.1225 sf(s)/Unit Total: 2.4507 sf(s)

5052-H32 .090 Sheet

Batch 3019 IB 8-2-27

2.0	WATER JET-	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3072 (D3072-101 flat pattern)

Dwg Rev: A1 IB 8-2-27

Prog Rev: A1

2-Deburr if necessary IB 8-2-27

(22)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-2-27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08-2-27 (22)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- deburr if necessary

2- Bend as per dwg D3072

08/03/04 (21)

08/03/03 (21)

PTO
3rd page

Date: Wednesday, 27/02/2008 7:40:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET R/H

Job Number: 37636

Part Number: D30722

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/06 (21)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

82

08-03-05

(21)

8.0

POWDER COATING

POWDER COATING



M 100700



(21X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1

08/03/06

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-03-06

(21)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5763

10 8/3/06

(21)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

(21)

Job Completion



in 2008/3/06

(21)

Date: Tuesday, 2/26/2008 8:02:17 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 37636
 Estimate Number : 11550
 P.O. Number :
 This Issue : 2/26/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : 1080226
 Comment : Est. B 02.01.18 Flat pattern created on dash 101. NG

Part Number : D30722
 Drawing Number : D3072 REV A1
 Project Number : N/A
 Drawing Revision : A1
 Material :
 Due Date : 3/14/2008 Qty: 20 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3072101 Bracket (flat)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bracket (flat)

Pick:

Qty	Part Number	Description	Batch
1	D3072-101	Bracket	

Waterjet

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend as per dwg D3072

Dash 1 bending detail (LH)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0 POWDER COATING POWDER COATING




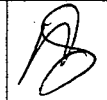
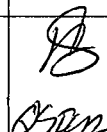
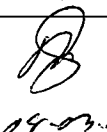
Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/03	5	1 part was scrap out of tolerance		Scrap + destroy	SS 08/03/03	 08-03-03	 08-03-03	 08-03-03

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37636

Part Number: D30722

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

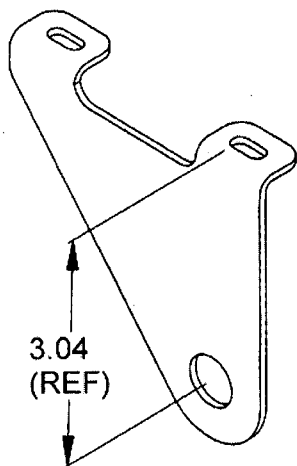
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3072	REV. A SHEET 1 OF 1
DATE 01.12.16		TITLE BRACKET	SCALE 1:1
A	01.12.16	NEW ISSUE	
068	A1 02.01.18	ADD FLAT PATTERN PART NUMBER <i>A CP</i>	



Technical drawing of a vertical plate with a top flange. The flange has a width of 0.68 and a height of 3.04. The corner is rounded with a radius of R0.100.

1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/
QQ-A-250/8) 0.090 THICK

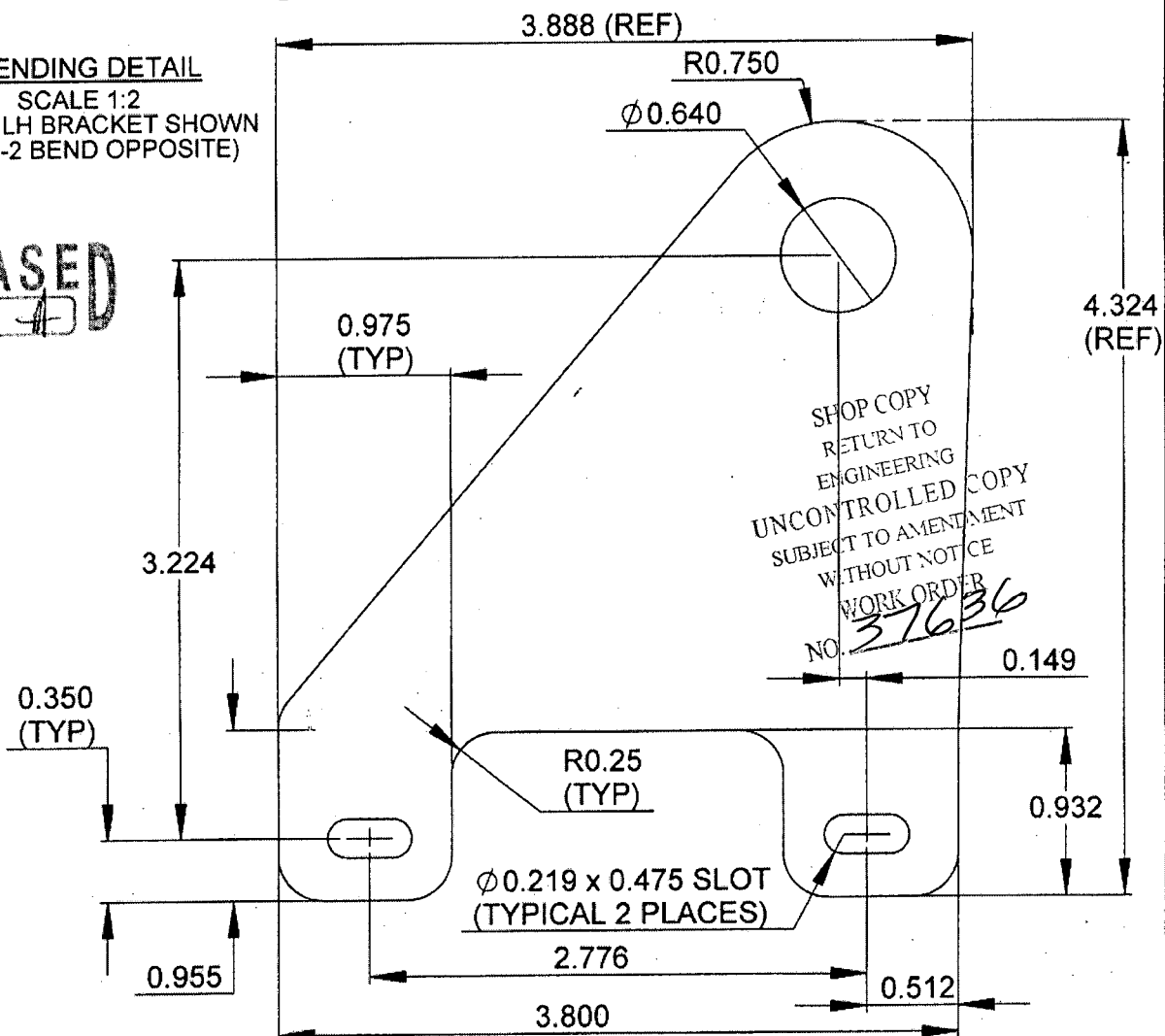
2) FINISH: POWDER COATBLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.

4) ALL DIMENSIONS ARE IN INCHES.

SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02-01-15



D3072-101

FLAT PATTERN FOR D3072-1/-2

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